

Date: Thursday, 11/15/2007 1:27:05 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BATTERY LOCK ASSEMBLY
 Job Number : 35778
 Estimate Number : 10900
 P.O. Number : *NA*
 This Issue : 11/15/2007 S.O. No. : *NA*
 Prsht Rev. : NC
 First Issue : *NA* Type : MACHINED PARTS
 Previous Run : 33813
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 05-11-22 JLM

Part Number : D3393041
 Drawing Number : D3393 UNDER REVIEW *REV A*
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 12/20/2007 Qty: *2* Um: *10* Each

Additional Product

Key alike

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D27287 Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2728-7

Decal

*22554**AS**08/01/10**(X)*

2.0 D33731 Cam Lock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3373-1

Cam Lock

*23043**AS**08/01/10**(X)*

3.0 516WC SS Flat Washer 5/16



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 5/16WC

SS Flat Washer

*M100737**AS**08/01/10**(X)*

4.0 D33931 Battery Lock Casing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3393-1

Battery Lock Casing

*35008**AS**08/01/10**(X)*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 35778

Part Number: D3393041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D33933

Cam Lock Shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3393-3

Cam Lock Shaft

23536

JS 08/01/10

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

SAD 08/01/11

2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5

08/01/11

3-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten with lock body nut, apply locktite, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3393-3 shaft into lock, then install decal.

A/RN/A262 Locktite

4109483

SAD

08/01/11

4-Identify as D3393-041 and attach keys. Ensure that assembly locks and unlocks smoothly. Record the Key

Key Numbers

1- 0420A

5- _____

2- 0420A

6- _____

3- 0420A

7- _____

4- _____

8- _____

SAD 08/01/11 2

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack Weld lock shaft to flat cam of a Max 1/8" Long

Qty Part Number Description Batch

A/R N/A

SS Rod

N/A

FC 08/01/11 (2)

Process Sheet

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Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 35778

Part Number: D3393041

Job Number:



Seq. #:

Machine Or Operation:

Description:

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-01-11 (2)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

SAD 08/01/11 (2)

Apply Crazy Glue to cap and press into Body

9567K21

Batch M17089

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/11 (V2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 48/

8/1/11 50

(2x)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/11 (2)

Job Completion



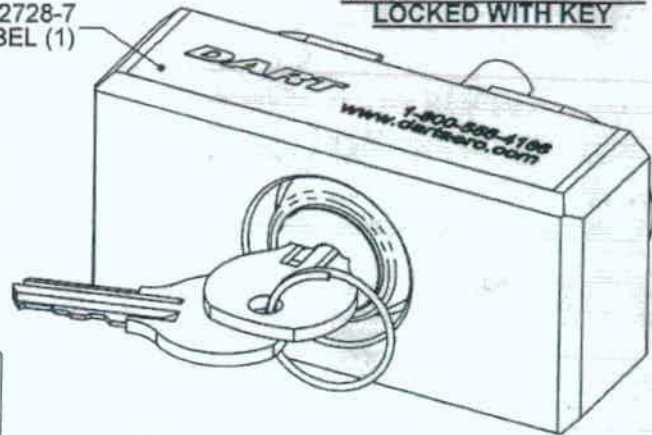
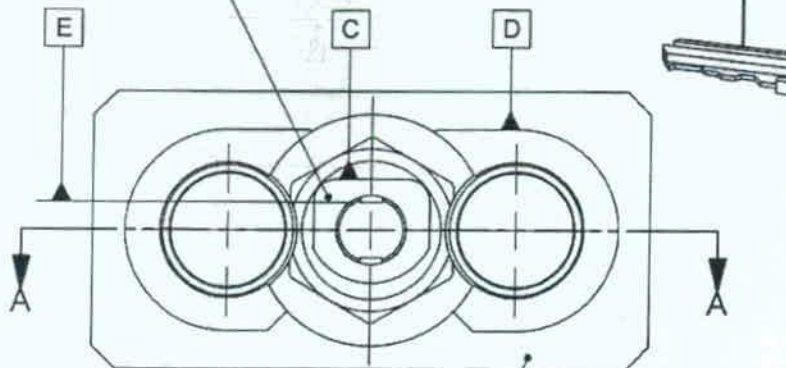
08-01-11

DART

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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3393 | REV. A SHEET 1 OF 3 |
| DATE 05.02.08 | | TITLE BATTERY LOCK | SCALE 1:1 |
| A | 05.02.08 | NEW ISSUE | |

RELEASED
[Signature]

05/03/09

D2728-7
LABEL (1)**BATTERY LOCK SHOWN
LOCKED WITH KEY**POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWND3373-1
CAM LOCK
ASSEMBLY (1)D3393-1
CASING (1) $\varnothing 5/16"$ WC S/S
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2) Δ
AND APPLY KRAZY GLUED3393-3 CAM
LOCK SHAFT (1) $0.09^{+0.03}_{-0.01}$ (2 PLACES)TACK WELD
D3393-3 TO D3369-5**SECTION A-A****D3393-041 BATTERY LOCK ASSEMBLY****NOTES:**

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMaster-Carr, P/N 9567K21

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WORK ORDER
NO. _____

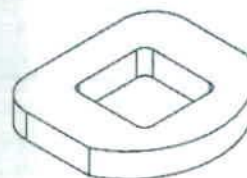
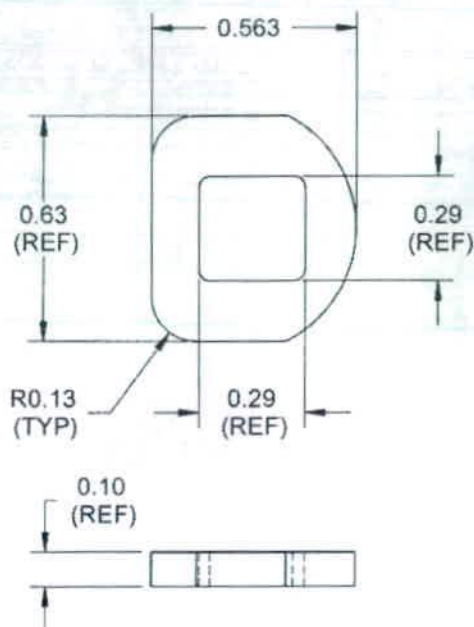
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3369 | REV. A |
| DATE 04.12.16 | | TITLE BATTERY LOCK | SHEET 4 OF 4 SCALE 2:1 |

SPECIFICATION CONTROL DRAWING

RELEASED
[Signature]

05/02/11

wlo 35778

-5
D3369 SPACER



NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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